

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021230**Date Inspected:** 11-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#14

East Side

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint #026 located on 14E, SEG3019N. Welder is identified as 068091. ZPMC Quality Control (QC)

Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM.

Repair welding of a weld joint #085 located on 13AE, SEG3007E as per the weld repair report # B-WR20179.

Welder is identified as 068924. ZPMC Quality Control (QC) Inspector is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-FCM-Repair-1.

Repair welding of a weld joint #133 located on 13AE, edge plate to floor beam, SEG3007N as per the weld repair report#B-WR20188. Welder is identified as 037743. ZPMC Quality Control (QC) Inspector is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G

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(3F)-FCM-Repair-1.

Repair welding of a weld joint #069 located on 13AE, SEG3007E as per the weld repair report # B-WR20179. Welder is identified as 068924. ZPMC Quality Control (QC) Inspector is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-FCM-Repair-1.

Weld joint #026 located on 14E, SEG3019N. Welder is identified as 066179. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM.

Flux Cored Arc Welding (FCAW):

Weld joint #031 located on 13AE, SEG3007AV. Welder is identified as 066163. ZPMC Quality Control (QC) Inspector is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB.

Weld joint #001 located on 13CE, SEG3011A. Welder is identified as 066881. ZPMC Quality Control (QC) Inspector is identified as Zhong Yong Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-ESAB.

Weld joint #066 located on 13AE, SEG3007AV. Welder is identified as 066163. ZPMC Quality Control (QC) Inspector is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #054 located on 14E, SEG3019L. Welder is identified as 067520. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #001 located on 13CE, SEG3009E. Welder is identified as 067138. ZPMC Quality Control (QC) Inspector is identified as Zhong Yong Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #032 located on 13AE, SEG3007AV. Welder is identified as 066163. ZPMC Quality Control (QC) Inspector is identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB.

Weld joint #125 located on 14E, SEG3019BB. Welder is identified as 067079. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #054 located on 14E, SEG3019L. Welder is identified as 067520. ZPMC Quality Control (QC) Inspector is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

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documents.

### Summary of Conversations:

No Relevant Conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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